

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006867**Date Inspected:** 20-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 5/20/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works, Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2E3 - During QA Inspectors walk through of Fabrication Shop #4 he observed two men actively working on removing of remaining weld that once secured the stay bars (distortion control) by way of Oxy-Acetylene cutting followed by grinding to a more flush condition. No weld was being performed on W2E3 during QA Inspector's review of shop operations.

W2W1 - As QA Inspector was performing his walk through, the assembled section was having its welds contour ground, the remaining plate to cast stem weld will be performed at an undetermined time, as disclosed by QC CWI Mr. Chung Fu Kuan and again reiterated by night shift CWI, Makhmud Ashadi. Process was taking place until end of inspector's shift.

W2W2 - Saddle Cast section is stowed in Foundry awaiting transfer to Fabrication Shop #4 and the completion of built up plate section. Built up section, in Fabrication shop #4, was observed by QA Inspector as having welds inspected by Magnetic Particle inspection (dry) by JSW Nikko Inspection technician M.Sato #81. Inspection was still in process at the end of QA inspector's shift.

W2W3 - Cast section has been relocated before move to Fabrication shop #4. QA Inspector noted the built up section as having had root passes completed on 8 of the 16 plates/ribs, verticals only. No work was being performed through QA Inspector's shift.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

TOWER SADDLES

T1-2 - During the QA Inspector's observance of Tower Saddle T1-2, welder K.Kobayashi 08-5023 was welding joint 8Y-10L-1 and -2 utilizing SMAW process, E7016 5mm electrode, per WPS SJ-3012-2. These welding operations continued through to end of QA Inspectors shift.

T1-3 - Saddle is in process of being joined to its built up plate steel section. QA Inspector noted two welders performing FCAW process on joints 9Y-9U and 9Y-10U, welders M.Inoue 92-5683 and S. Hayashi 05-3113, respectively, used 1.6mm TM55 consumable wire. The WPS SJ-3012-5 procedure was employed and the variables monitored by QC CWI Mr. Chung Fu Kuan.

EAST DEVIATION SADDLES

E2E1 - As QA Inspector was in the Foundry the Casted Saddle section was in process of moving to a location to begin NDE process of the now newly, as finished, condition. No testing had begun before QAI had completed his rounds in the Foundry.

E2W1 - The Casted Saddle section is now having the excavations tested by means of Penetrant and Magnetic particle to assure removal of previously noted indications. Grinding was being conducted while QA Inspector completed rounds.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
